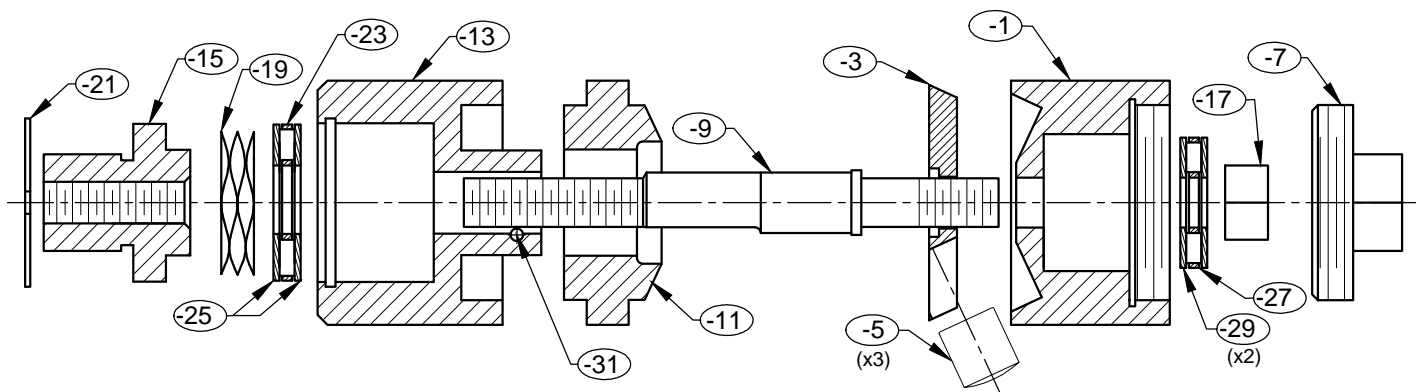


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



UNDER REVIEW
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NOTES

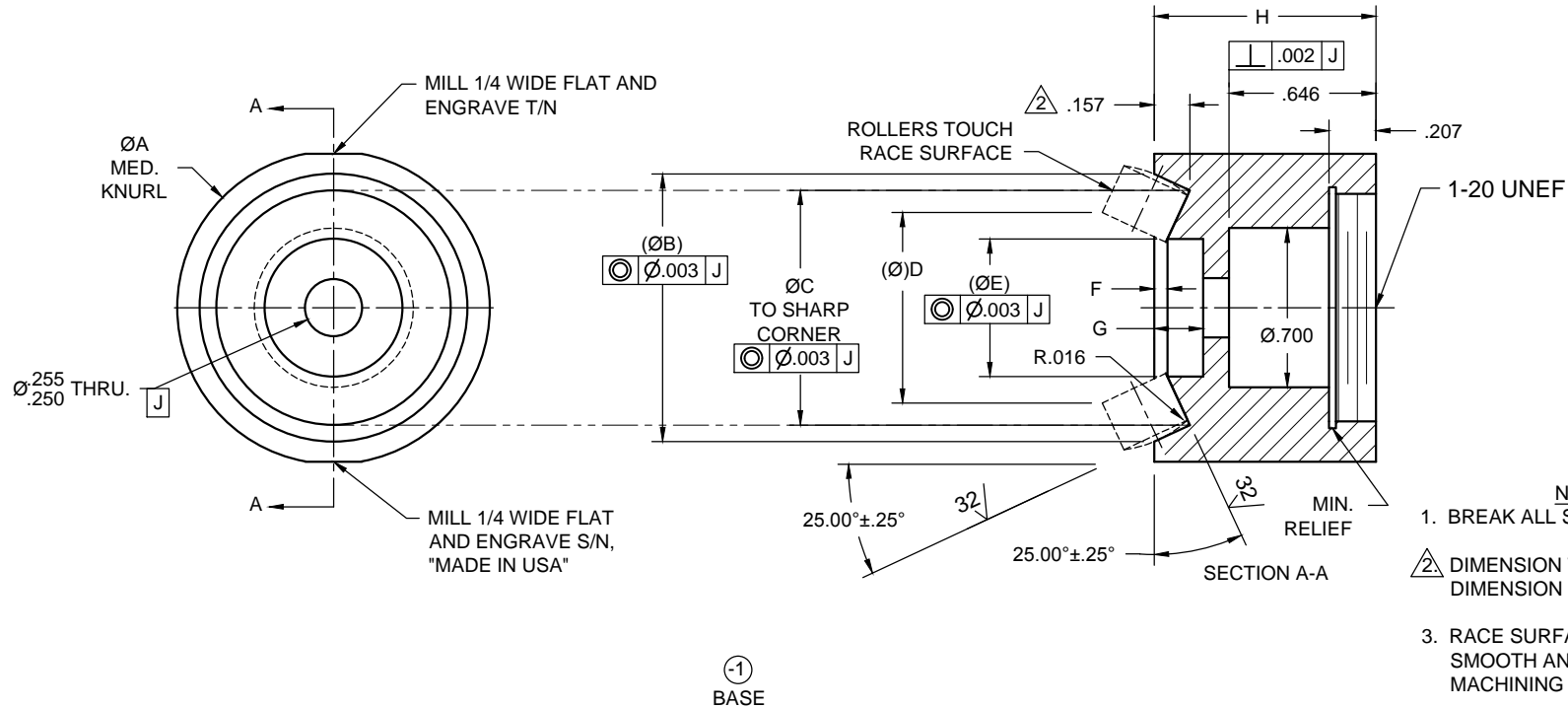
- 5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
- FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BASE		SEE CHART	2
			-3	1	RETAINER		SEE CHART	3
			-5	3	ROLLER		SEE CHART	4
			-7	1	CAP		SEE CHART	5
			-9	1	STUD		SEE CHART	6
			-11	1	DUAL SEAT		SEE CHART	7
			-13	1	RECEIVER		SEE CHART	8
			-15	1	TENSIONER		SEE CHART	9
		B/O	-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 Ht. MCMMASTER-CARR #95065A150	1
		B/O	-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD., .550 ID., WIRE THICK. .013, THREE TURNS SMALLEY RING CO. #CS075-H1	1
		B/O	-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMMASTER-CARR #99142A410	1
		B/O	-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1
		B/O	-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1
		B/O	-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1
		B/O	-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1
		B/O	-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
NHBY6V204	RBW1005-P
109-0133-11-101	

RED BARN MACHINE	
TITLE PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBW1005-P	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE NTS	DATE 11-9-09
SHEET 1 of 9	USED ON BEARING SEE CHART

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



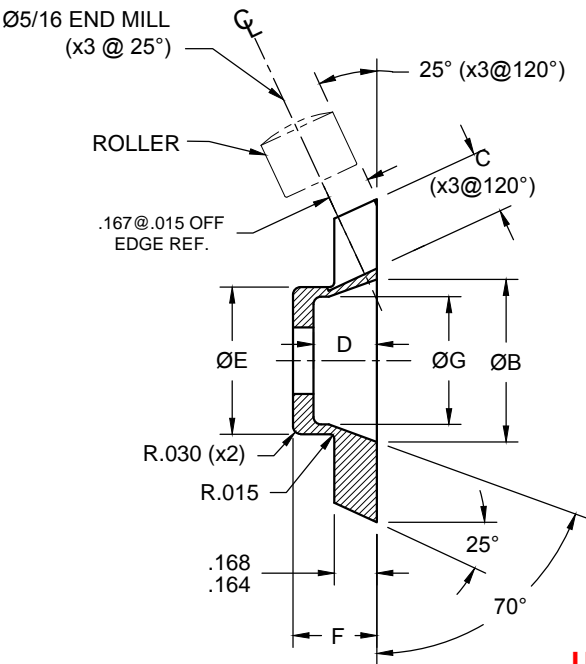
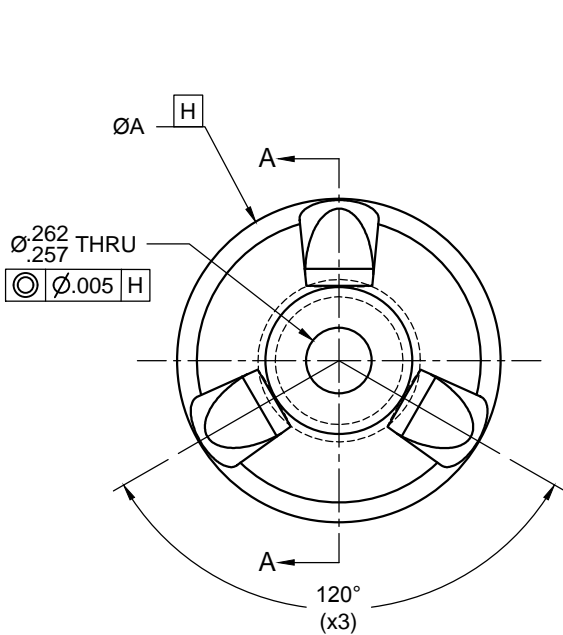
- NOTES**
- BREAK ALL SHARP CORNERS (.015/.03).
 - DIMENSION TO BOTTOM OF R.016=.153; DIMENSION TO SHARP CORNER=.158.
 - RACE SURFACE OF -1 BASE MUST BE SMOOTH AND FREE OF GROOVES & MACHINING MARKS.
 - MUST HOLD ØC POSITION AND ANGLE TOLERANCES TO MAINTAIN PITCH DIA..
 - DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.

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TOOL #	ØA +000 -020	ØB +006 -002	ØC +006 -002	ØD P.D. REF.	ØE +006 -002	F +003 -003	G +005 -005	H +010 -010	MATERIAL
RBW1005-P	1.375	1.177	1.031	.837	.605	.058	.215	.975	O-1 DRILL ROD Ø1-3/8 x 1-1/8

RED BARN MACHINE	
TITLE PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBW1005-P-1	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .005	ANGLES ± 5°
.XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09
SHEET 2 of 9	

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



-3
 RETAINER

SECTION A-A
 UNDER REVIEW
 URF 19-1121 19.10.30 (VM)

- NOTES
 1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA + .002 - .002	ØB + .005 - .005	C + .003 - .003	D + .010 - .010	ØE + .005 - .005	F + .005 - .005	ØG + .005 - .005	P.D. REF.	MATERIAL
RBW1005-P	1.265	.635	.247	.250	.575	.328	.500	.837	BRONZE RND. BAR Ø1-3/8 x 1/2

RB

RED BARN MACHINE

TITLE

PORTABLE TRI-ROLLER SWAGING TOOL

DWG NO.

RBW1005-P-3

REV

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES ON:

DECIMALS

.XXX ± .005

.XX ± .01

X ± .1

FRACTIONS ± 1/32

ANGLES ± 5°

UNLESS OTHERWISE SPECIFIED

1. BREAK ALL SHARP EDGES

015 x 45° PR .015 R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE

NTS

DATE

11-9-09

SHEET

3 of 9

DRAWN BY:

PERRITT

APPROVED

D Weil

HEAT TREAT FINISH

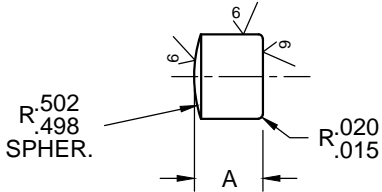
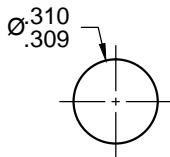
SPEC

USED ON BEARING

SEE CHART

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



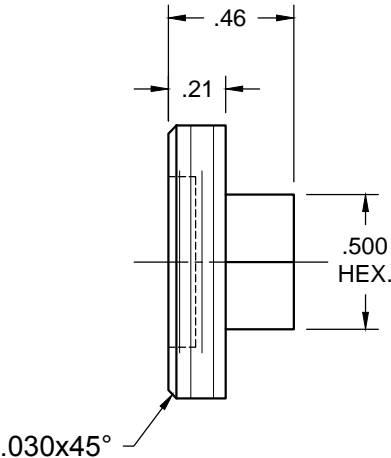
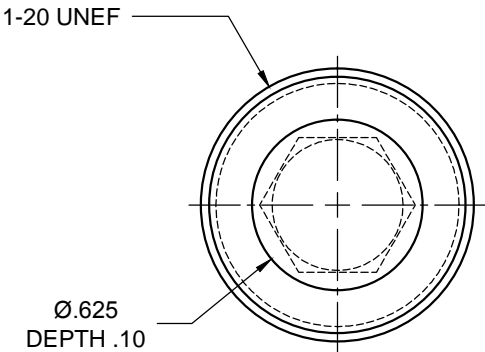
⑤
ROLLER

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TOOL #	A +.001 -.001	MATERIAL
RBW1005-P	.251	.310 MINUS GAUGE PIN MSC #89031009

 RED BARN MACHINE	
TITLE PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBW1005-P-5	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT RC 55-60 FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE CHART
SCALE NTS	DATE 11-9-09
SHEET 4 of 9	


REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



⑦
CAP


UNDER REVIEW
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TOOL #		MATERIAL
RBW1005-P		1018 RND. BAR Ø1 x 5/8

<div>  RED BARN MACHINE </div>			
TITLE PORTABLE TRI-ROLLER SWAGING TOOL			
DWG NO. RBW1005-P-7			REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1		DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH: BLACK OXIDE SPEC:	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE CHART	
SCALE NTS	DATE 11-9-09	SHEET 5 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

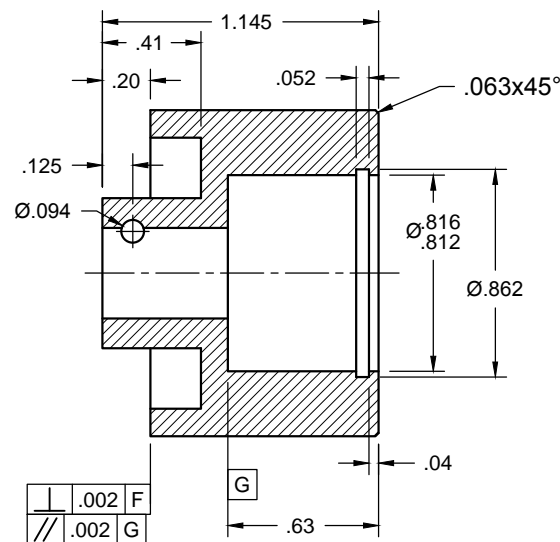
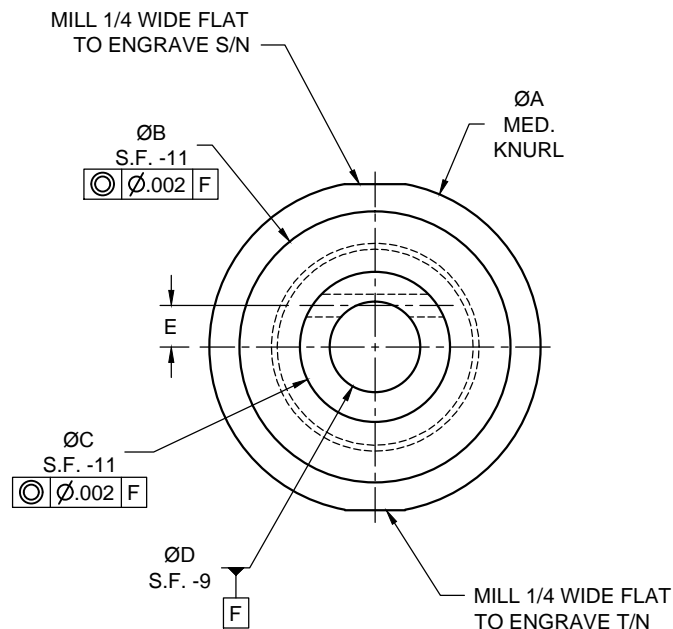


 RED BARN MACHINE			
TITLE PORTABLE TRI-ROLLER SWAGING TOOL			
DWG NO. RBW1005-P-9			REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED: <i>D Weid</i> HEAT TREAT: FINISH: BLACK OXIDE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SPEC USED ON BEARING SEE CHART	
SCALE NTS	DATE 11-9-09	SHEET 6	of 9

 RED BARN MACHINE			
TITLE PORTABLE TRI-ROLLER SWAGING TOOL			
DWG NO. RBW1005-P-11			REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED: <i>D Weid</i> HEAT TREAT FINISH: BLACK OXIDE SPEC:	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE CHART	
SCALE NTS	DATE 11-9-09	SHEET 7 of 9	

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(-13)

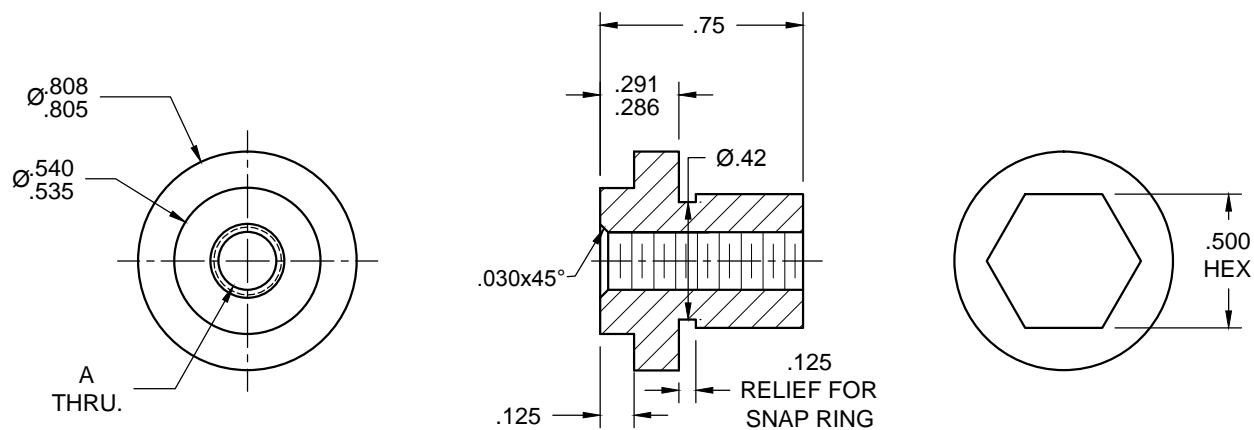
RECIEVER

TOOL #	ØA +.010 -.010	ØB +.003 -.000	ØC +.003 -.003	ØD +.002 -.000	E +.003 -.000	MATERIAL
RBW1005-P	1.375	1.125	.622	.312	.175	4140 Q&T RND.BAR Ø1-3/8 x 1-1/4

RED BARN MACHINE	
TITLE PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBW1005-P-13	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH: BLACK OXIDE SPEC USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09
SHEET 8 of 9	

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(-15)
TENSIONER

TOOL #	A	MATERIAL
RBW1005-P	1/4-28 UNF	4140 Q&R RND. BAR Ø7/8 x 7/8

RED BARN MACHINE	
TITLE PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBW1005-P-15	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09 SHEET 9 of 9

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 RED BARN MA

RED BARN MACHINE


RED BARN MACHINE

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URF 19-1121 19.10.30 (VM)

	PART #	QTY	DESCRIPTION
	-1	1	--

DRAWN BY: PERRITT	 RED BARN MACHINE
CHECKED	
HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	

USED ON MODEL	TITLE
?	

UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DWG NO. PART #	REV.
	SCALE NTS	DATE 1-28-06
		SHEET 1 of 1